

Work Order ID 120870

120870

Page 1

June-12-14 9:45:19 AM

Item ID: D407-667-105TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Turning Detail

Start Date: 6/12/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/12/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-06-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|--------------|-------|
| D407-667-145 | Rev C |
|--------------|-------|

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8673 on both ends as per Folio FA249

2-Turn first side as per Folio FA249

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: AA

DWG REV: C

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00

110

QC

Memo

0.00

Quality Control

mmil
14/06/23

mmil
14/06/23

Work Order ID 120870

June-12-14 9:45:19 AM

120870

Page 2

Item ID: D407-667-105TRN Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Turning Detail
 Start Date: 6/12/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/12/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | MORI SEIKI CNC LATHE LARGE | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Mori Seiki | Memo | 0.00 | | | | | | | |
| Mori Seiki CNC Lathe Large | 1-Turn second side as per Folio FA249 | | | | | | | | |
| | 2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. FOLIO REV: <u> A </u> DWG REV: <u> C </u> 3-Remove sand and plugs | | | | | | | | |
| | 4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145 inside of Cuff(Do not engrave on outside of tube) | | | | | | | | |
| 130 | QC1- Inspect dimensions to dimension sheet | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

amm. L
14/06/24

amm. L
14/06/24

Work Order ID 120870

June-12-14 9:45:19 AM

120870

Page 3

Item ID: D407-667-105TRN

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Turning Detail

Stop ***NS2***

Start Date: 6/12/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/12/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 145 | | 0.00 | | | | | | | |
| *145* | | | | | | | | | |
| Crosstubes | Memo | 0.00 | | | | | | | |
| Crosstubes | GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY. | | | | | | | | |
| 150 | | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| HandFXtube | Memo | 0.00 | | | | | | | |
| Hand Finishing Crosstubes | 1- PRESSURE WASH X-TUBE INSIDE AND OUT | | | | | | | | |
| | 2- ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE | | | | | | | | |

JW 14-06-26

de 14/06/26

de/15 14/06/26

Work Order ID 120870

June-12-14 9:45:19 AM

120870

Page 4

Item ID: D407-667-105TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Turning Detail

Start Date: 6/12/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/12/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC5- Inspect part completeness to step on W/O

0.00

160

DA

16

9-80

14/06/26

QC

Memo

0.00

Quality Control

170

Packaging

0.00

170

Packaging

Memo

0.00

DC 14/06/26

Packaging

Identify and stock in Kanban rackLocation: LG

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

MCJ 14-06-27

Quality Control

ME 14-6-29

Picklist Print

June-12-14 9:45:23 AM

Page 1

Work Order ID: 120870

120870

Parent Item: D407-667-105TRN

D407-667-105TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 6/12/14

Required Date: 6/12/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:a08.02.28 new issueEC
IPP Rev B 08.04.02 Removed polish EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6010-115 | | Manufactured | No | | | 110 | Each | 48.0000 | 1 | 1 | | | |

D6010-115

Crosstube Material

Location

Loc Qty

Loc Code

LG003

48

107878

36

5640

12

mm L 14/06/14

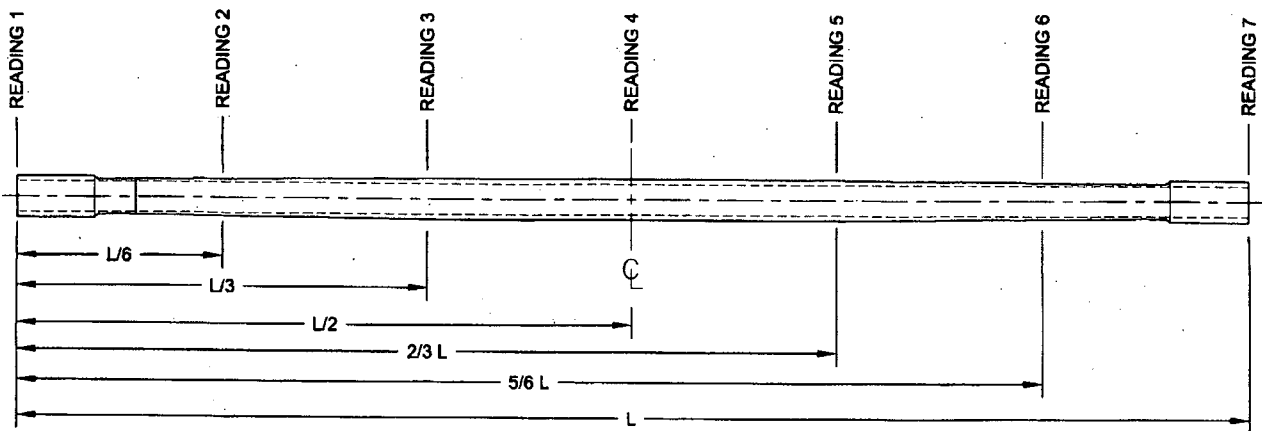
| | | | |
|--|--|---------------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 120870 |
| Description: Crosstube Assembly | | Part Number: | D407-667-145 |
| Inspection Dwg: D407-667-145 Rev: C | | Page 1 of 2 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Inspection Sheet Drawing Dimension | | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|--------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.240 | / | | vern | CNC-08 |
| | 1.865 | +0.005/-0.000 | 1.868 | / | | ↓ | |
| | 1.878 | +0.005/-0.000 | 1.878 | / | | | |
| | 1.970 | +0.005/-0.000 | 1.973 | / | | | |
| | 2.030 | +0.005/-0.000 | 2.035 | / | | | |
| | 2.165 | +0.005/-0.000 | 2.169 | / | | | |
| | | | | | | | |
| | 0.125 | +/-0.010 | .125 | / | | vern | CNC-08 |
| | R0.063 | +/-0.010 | .063 | / | | R6 | |
| | R0.500 | +/-0.010 | .500 | / | | " | |
| | R0.063 | +/-0.010 | .063 | / | | " | |
| | 4.438 | +/-0.030 | 4.435 | / | | vern | CNC-08 |
| SIDE B | 2.240 | +0.005/-0.000 | 2.242 | / | | vern | CNC-08 |
| | 1.865 | +0.005/-0.000 | 1.867 | / | | ↓ | |
| | 1.878 | +0.005/-0.000 | 1.878 | / | | | |
| | 1.970 | +0.005/-0.000 | 1.972 | / | | | |
| | 2.030 | +0.005/-0.000 | 2.034 | / | | | |
| | 2.165 | +0.005/-0.000 | 2.169 | / | | | |
| | | | | / | | | |
| | | | | | | vern | |
| | 0.125 | +/-0.010 | .125 | / | | vern | CNC-08 |
| | R0.063 | +/-0.010 | .063 | / | | R6 | |
| | R0.500 | +/-0.010 | .500 | / | | " | |
| | R0.063 | +/-0.010 | .063 | / | | " | |
| | 4.438 | +/-0.030 | 4.435 | / | | vern | CNC-08 |
| | 113.20 | +/-0.020 | 113.190 | / | | tape | LB-11 |

| | | |
|--|--|----------------------------------|
| DART AEROSPACE LTD | | Work Order: 120870 |
| Description: Crosstube Assembly | | Part Number: D407-667-145 |
| Inspection Dwg: D407-667-145 Rev: C | | Page 2 of 2 |

WALL THICKNESS MEASUREMENT



| Location | WALL THICKNESS MEASUREMENT (IN) | | | | Deviation Δw (max-min) | TOLERANCE |
|-------------------------|---------------------------------|------|------|------|--------------------------------------|-----------|
| | w1 | w2 | w3 | w4 | | |
| READING 1 L= 0" | .322 | .325 | .315 | .317 | .008 | 0.042" |
| READING 2 L= 19 | .186 | .183 | .181 | .183 | .003 | |
| READING 3 L= 37.5 | .274 | .276 | .279 | .278 | .009 | |
| READING 4 L= 56.5 | .320 | .320 | .320 | .327 | .007 | |
| READING 5 L= 75.5 | .278 | .277 | .279 | .277 | .003 | |
| READING 6 L= 94 | .189 | .178 | .176 | .183 | .013 | |
| READING 7 L= 113.200 | .320 | .315 | .323 | .326 | .011 | |

Calibration Result

Actual Block Thickness: 100 - 750

SITESCAN 250 Measured Thickness: 100 - 750

| |
|---------------------------|
| Measured by: ANM-L |
| Date: 14/06/25 |

| |
|-----------------------|
| Audited by: TW |
| Date: 14-06-26 |

| |
|------------------------------|
| Preliminary Approval: |
| Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|----------|
| A | 04.04.21 | New Issue (P/O D407-667-105) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |
| C | 09.06.11 | Dwg Rev updated | KJ | |
| D | 11.06.21 | Tolerance revised for 4.438 dimension | KJ | |
| E | 12.06.04 | Wall thickness form added | KJ | |

| Item | Qty | Part Number | Description |
|------|------|----------------|---|
| | -145 | | |
| 1 | X | D407-667-145 | CROSSTUBE ASSEMBLY (407 HIGH FWD) |
| 2 | 1 | D6010-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

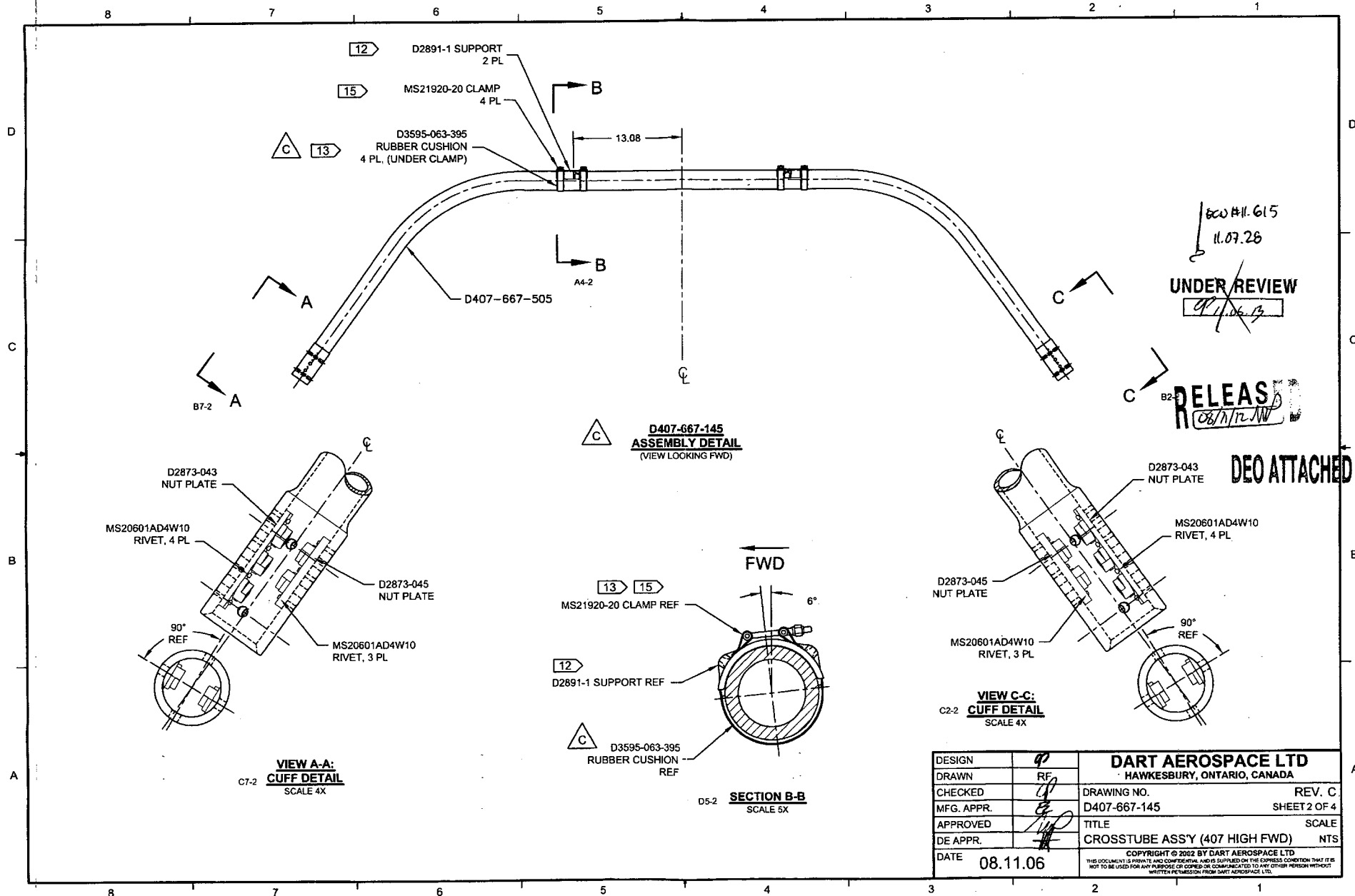
SHOW COPY
RETRACTED
FINDING
UNCON
SUB
WORK ORDER
NO. 120870 MJS
1406-12
DEO ATTACHED

ECW #11-615
11.07.26

UNDER REVIEW

RELEASED
08/11/12 MJS

| | | | |
|------------|---|--|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 02.05.08 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D407-667-145 | SHEET 1 OF 4 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | CROSSTUBE ASSY (407 HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

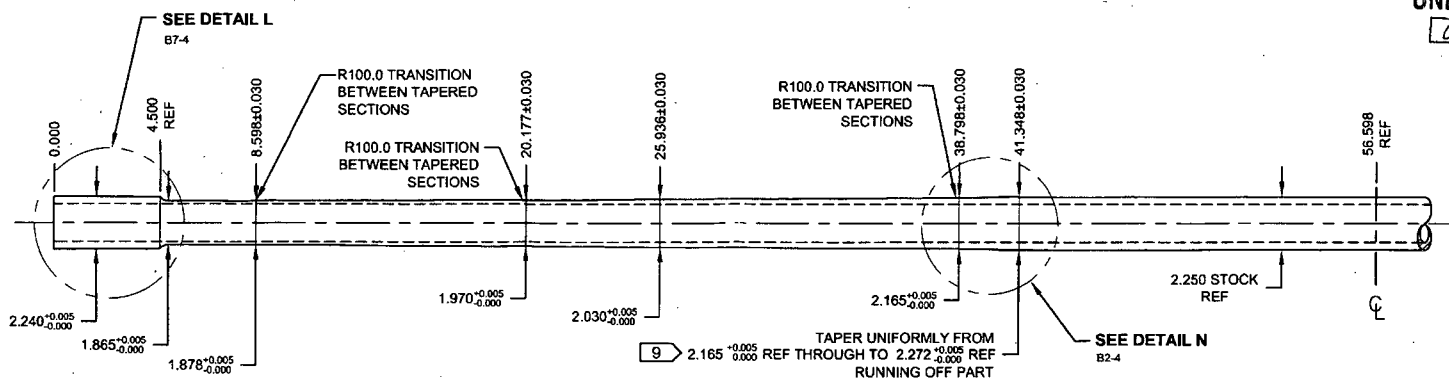


UNDER REVIEW

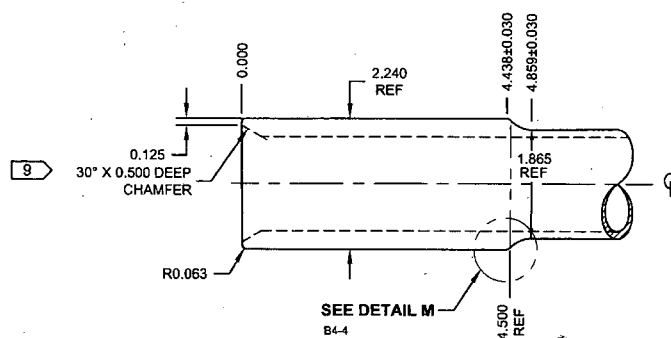
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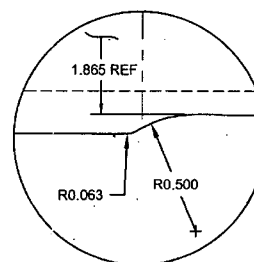
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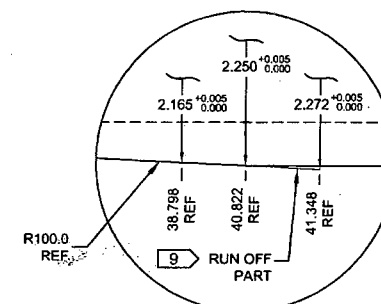
TURNING DETAIL



DETAIL L:
D7-4 CROSSTUBE CUFF
NOT TO SCALE



DETAIL M:
B5-4 CUFF TRANSITION
NOT TO SCALE



DETAIL N:
C3-4 TAPER RUN-OFF
NOT TO SCALE

DEO ATTACHED

RELEASED

| | | | |
|--|----------|--|--------------|
| DESIGN | 08 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 08 | DRAWING NO. | REV. C |
| MFG. APPR. | 08 | D407-667-145 | SHEET 4 OF 4 |
| APPROVED | 08 | TITLE | SCALE |
| DE APPR. | 08 | CROSSTUBE ASSY (407 HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2002 BY DART AEROSPACE LTD | |
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| | | | | | | | |
|-----------------------------|---|------------------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D407-667-145 | TITLE CROSSTUBE ASS'Y (407 HIGH FWD) | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D407-667-145-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN 97 | CHECKED ASS | MFG. APPR. 18 | APPROVED WD | | DE APPR. ## | | |
| DATE 11.07.15 | DATE 11.07.22 | DATE 11.07.22 | DATE 11/07/22 | | DATE 11.07.21 | | |

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

| Item | Qty -145 | Part Number | Description |
|------|-------------|-----------------|-------------------------------|
| 9 | A/R | PROSEAL 890 B-2 | SEALANT, AMS-S-8802 CLASS B-2 |

WAS:

| | | | |
|---|-----|----------------|---|
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
|---|-----|----------------|---|

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRAD MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WD

| | | | | | | | |
|-----------------------------|---|---------------------------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D407-667-145 | TITLE CROSSTUBE ASS'Y (407 HIGH FWD) | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D407-667-145-C-2 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED [Signature] | MFG. APPR. [Signature] | APPROVED [Signature] | | DE APPR. [Signature] | | |
| DATE 12.08.02 | DATE 12.08.02 | DATE 12.08.02 | DATE 12.08.02 | | DATE 12.08.02 | | |

PURPOSE:

ADD ELECTRICAL GROUNDING STRAP

CHANGE:

| ITEM | QTY -145 | PART NUMBER | DESCRIPTION |
|------|-------------|---------------|-----------------------------------|
| 1 | X | D407-667-145 | CROSSTUBE ASSEMBLY (407 HIGH FWD) |
| | | | |
| 10 | 2 | AN742D36 | CLAMP |
| 11 | 2 | MS9165-05 | ANGLE BRACKET |
| 12 | 2 | MS21042L3 | NUT (OR MS21042-3) |
| 13 | 2 | MS27039-1-08 | SCREW |
| 14 | 4 | NAS1149C0332R | WASHER (OR AN960C10L) |

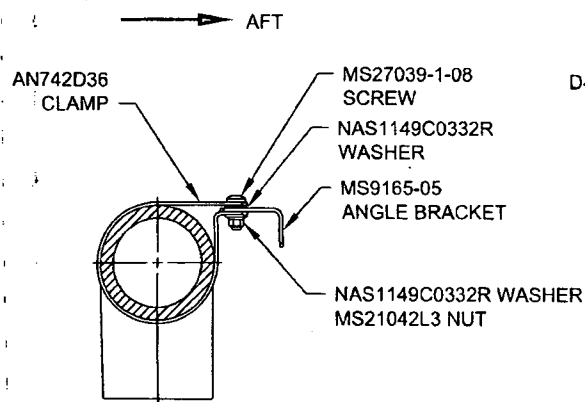
ADD

GENERAL NOTES:

- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS

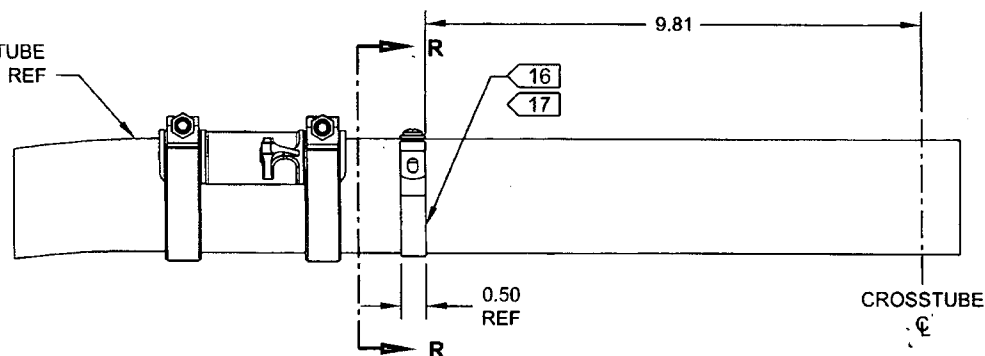
ADD

RELEASED
CP 12.08.17
ECN 12-631



SECTION R-R

D407-667-505 CROSSTUBE REF



DETAIL P
BONDING STRAP INSTALLATION 2 PL

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